

Date: Friday, 12/12/2008 7:43:20 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 44029	
Estimate Number : 10564	
P.O. Number :	Part Number : D34433
This Issue : 12/12/2008 S.O. No. :	Drawing Number : D3443 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 40561	Material :
Written By : <u>Jan 02.12.12</u>	Due Date : 19/12/2008 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est Rev: A 05.11.14 New issue EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304R1500

304 round bar 1.500



Comment: Qty.: 0.2500 f(s)/Unit Total: 2.5000 f(s)

M 106260 08/12/14

10 pcs

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA588 & DWG D3443

FOLIO REV: 9A

DWG REV: B

08/12/14

2-DEBURR AS REQUIRED

10 pcs

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/12/14

10 pcs

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA588 Rev: B & Dwg D3443 Rev: B

2-Deburr per dwg D3443

M. A 09/01/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 44029

Part Number: D34433

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A

09/01/18

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill hole as per Dwg D3443.

SB 09/01/22 (10)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SB 09/01/22 (10)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/01/23 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Carl

SS 09/01/23 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



mf 09-01-24

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D3065-5DART AEROSPACE LTD		Work Order: 440 29.
Description: Clevis		Part Number: D3443-3
Inspection Dwg: D3443	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.700	✓			
0.95	+/-0.030	0.950	✓			
Ø0.500	+0.000/-0.005	0.499	✓			
20°	+/-0.5°	20°	✓			
R0.450	+/-0.010	R0.450	✓			
Ø0.375	+0.006/-0.001	Ø0.377	✓			
0.451	+/-0.010	0.448	✓			
0.625	+/-0.010	0.624	✓			
1.53	+/-0.030	1.528	✓			
0.720	+/-0.010	0.7245	✓			
0.05 x 45°	+/-0.5°	0.05 x 45°	✓			
45°	+/-0.5°	45°	✓			
1.00	+/-0.030	1.000	✓			
1.125	+/-0.010	1.125	✓			
0.438	+0.005/-0.000	0.439	✓			
R0.050	+/-0.010	R0.040	✓			

Measured by: J. A	Audited by: gmk	Prototype Approval: N/A
Date: 08/12/14 / 09/01/18	Date: 09/01/23	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue	KJ/JLM	

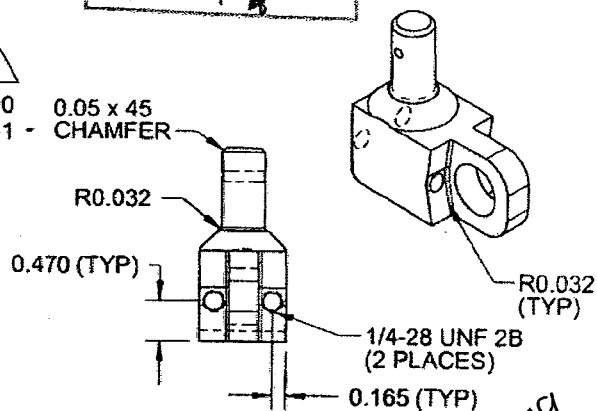
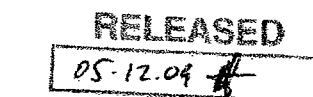
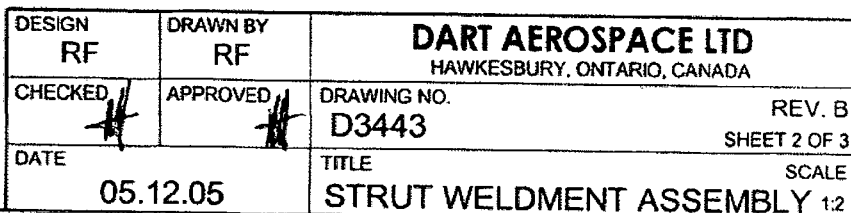
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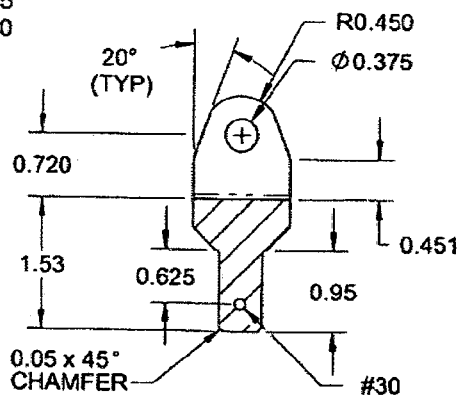
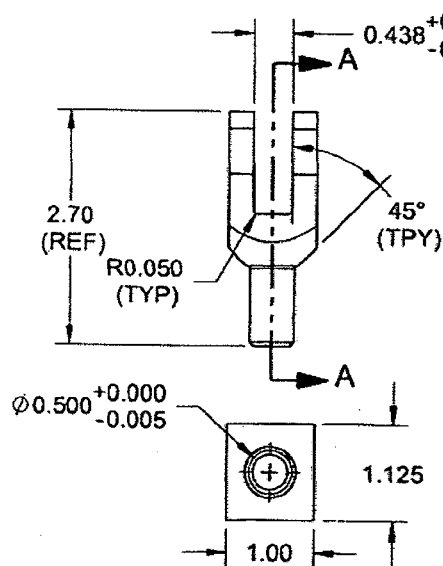
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1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS

1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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